

Date: Thursday, 5/4/2006 11:09:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP		
Job Number	: 26927		Part Number	: D31839		
Estimate Number	: 12401		Drawing Number	: D3183		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/4/2006 S.O. No. : N/A		Drawing Revision	: C1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: N/A		Due Date	: 5/10/2006 Qty: 400 Um: Each		
Written By	: See comment below					
Checked & Approved By	: JF 06.05.04					
Comment	: Est A 06.05.03 New issue KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR1000	Delrin Round Bar 1"	
		Comment: Qty.: 0.0350 f(s)/Unit Total : 13.9860 f(s) Delrin Round Bar 1" Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000) Identify as D3183-9 Batch: 3100672	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr	BC 06.05.08 403
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	BC 06.05.08 403
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	T.G 06/05/08 403
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: //	U 06.05.08 H03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

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Part Number: D31839

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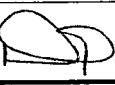


Seq. #:	Machine Or Operation:	Description :
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6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26927
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SG</u>	Audited by:	<u>SD</u>	Prototype Approval:	N/A
Date:	06.05.06	Date:	06.05.06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	 

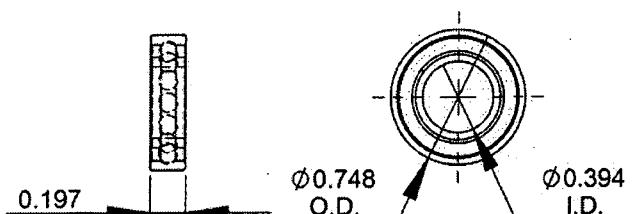
DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. C D3183 SHEET 1 OF 4
DATE	04.02.17	TITLE SCALE BRACKET ASSEMBLY 1:1
A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

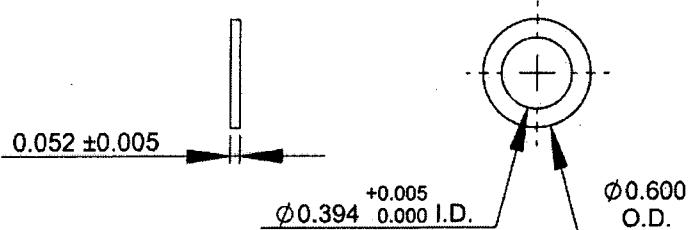
RELEASED
04.03.01D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)D3183-1 BRACKET FOR -041 (SHOWN)
OR
D3183-2 BRACKET FOR -042 (OPPOSITE)
OR
D3183-3 BRACKET FOR -043 (SIMILAR)
OR
D3183-4 BRACKET FOR -044 (SIMILAR)

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE,
CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

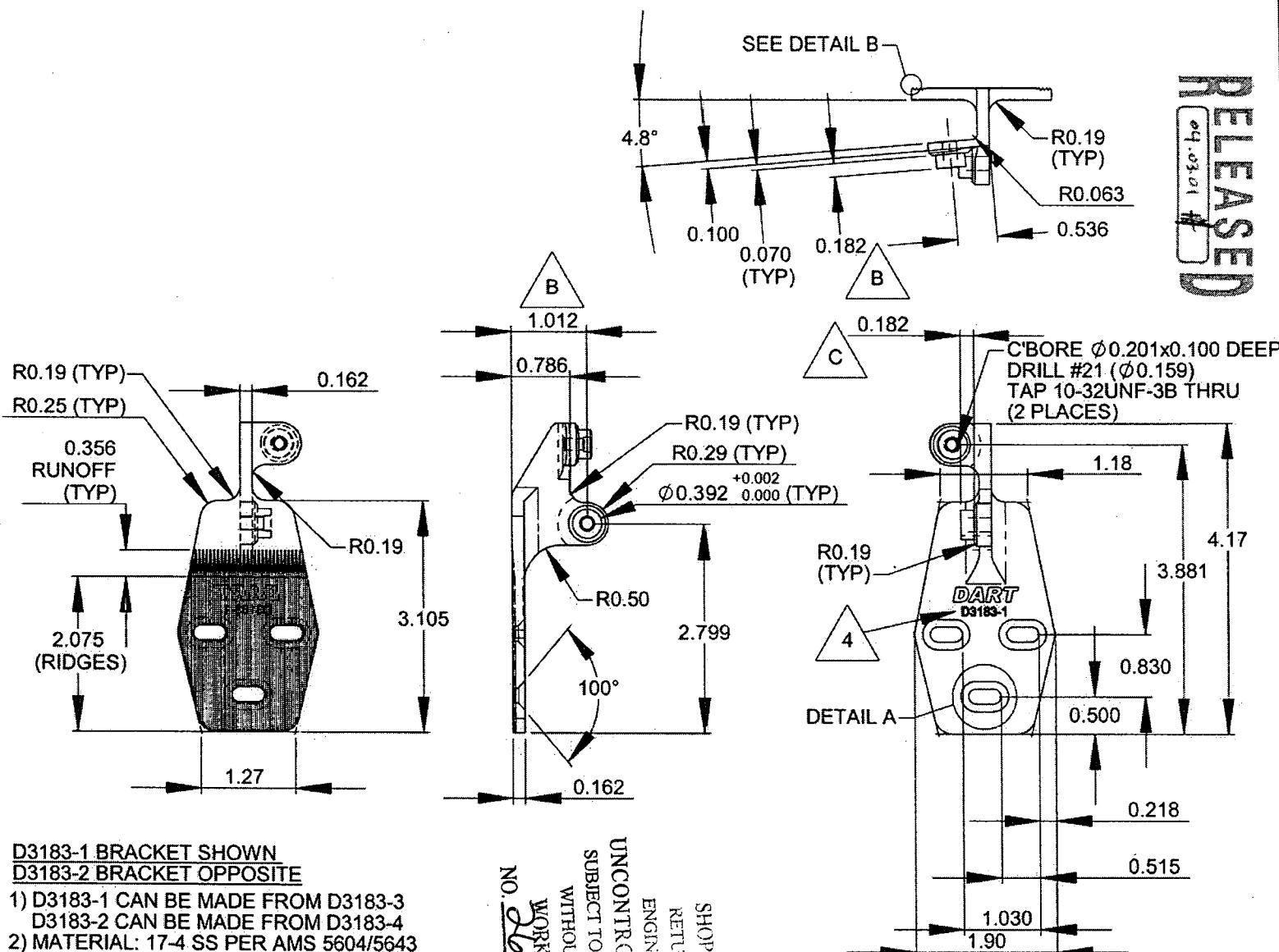


D3183-7 WASHER

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
TOLERANCES ARE PER DART QSI 048
UNLESS OTHERWISE NOTED OUT NOTICE
ALL DIMENSIONS ARE IN INCHES
WORK ORDER
NO. 26921

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		D3183
DATE		TITLE
04.02.17		BRACKET ASSEMBLY
		SHEET 2 OF 4
		SCALE
		1:2

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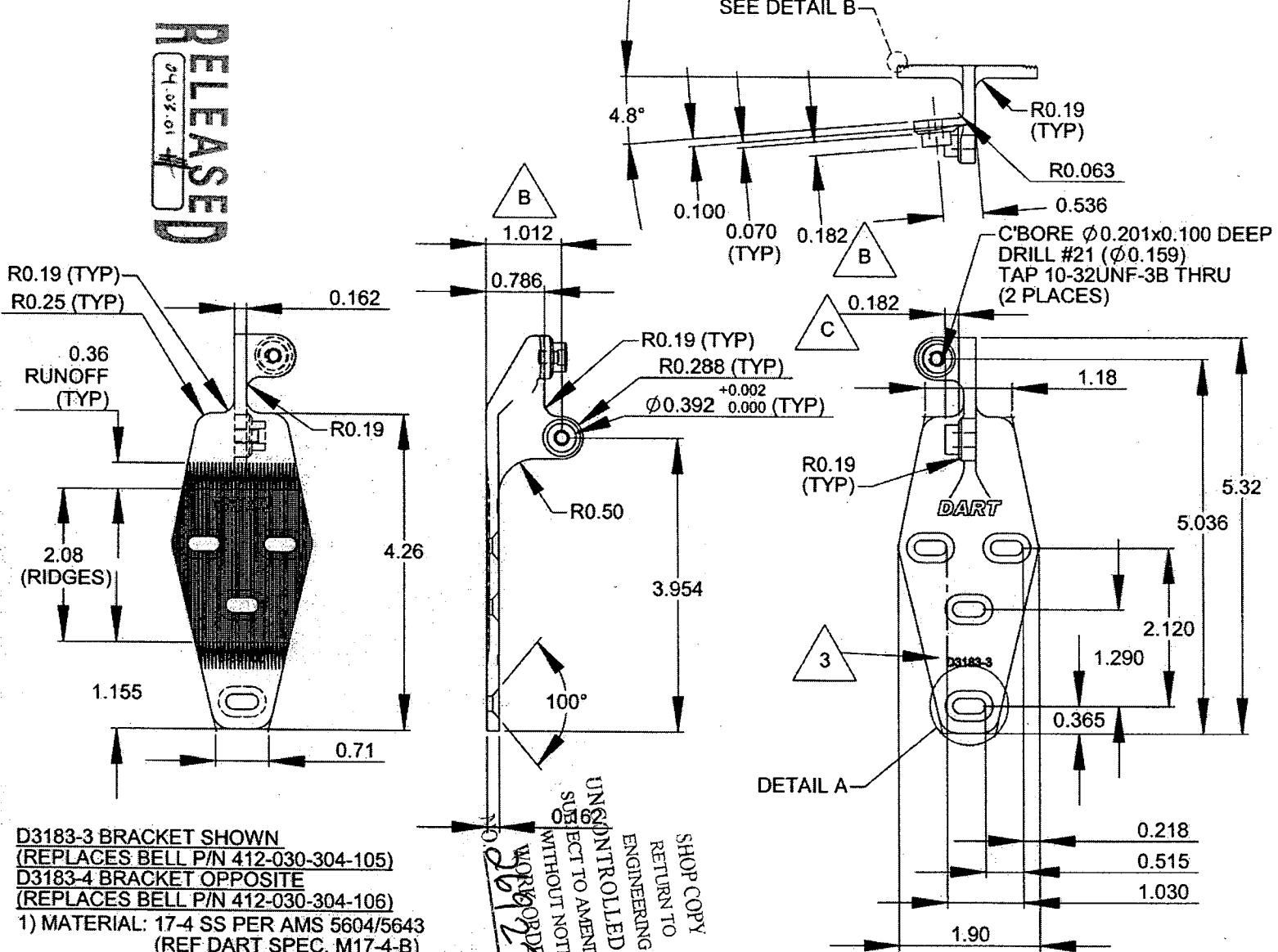
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- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

COPY TO
CEN

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CHECKED	APPROVED	DRAWING NO. D3183
DATE	04.02.17	TITLE BRACKET ASSEMBLY
		REV. C SHEET 3 OF 4 SCALE 1:2

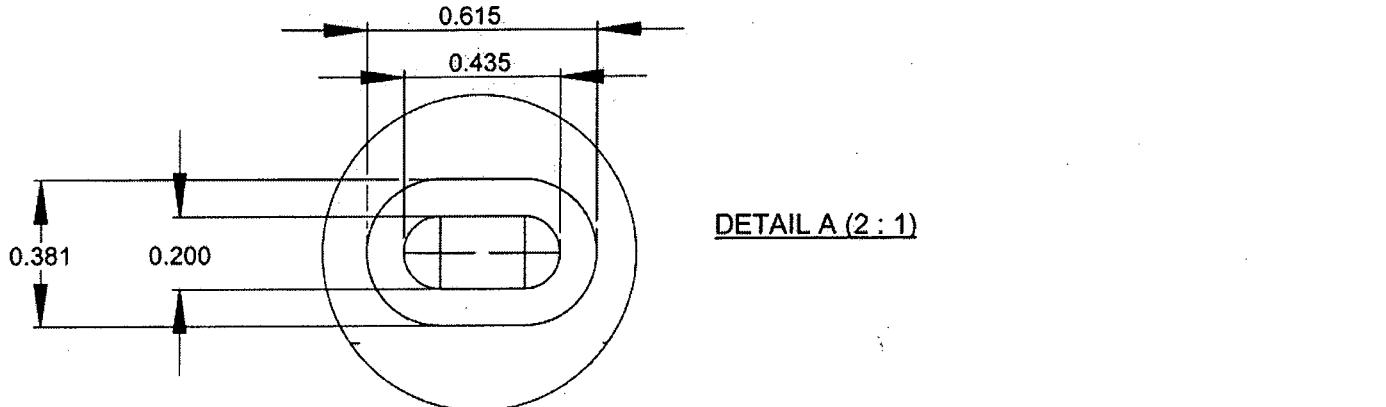
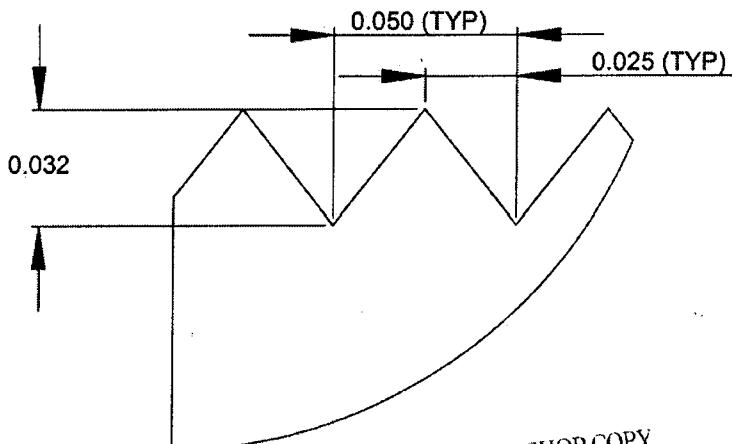


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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	

**RELEASED**
04.03.01DETAIL B (20 : 1)

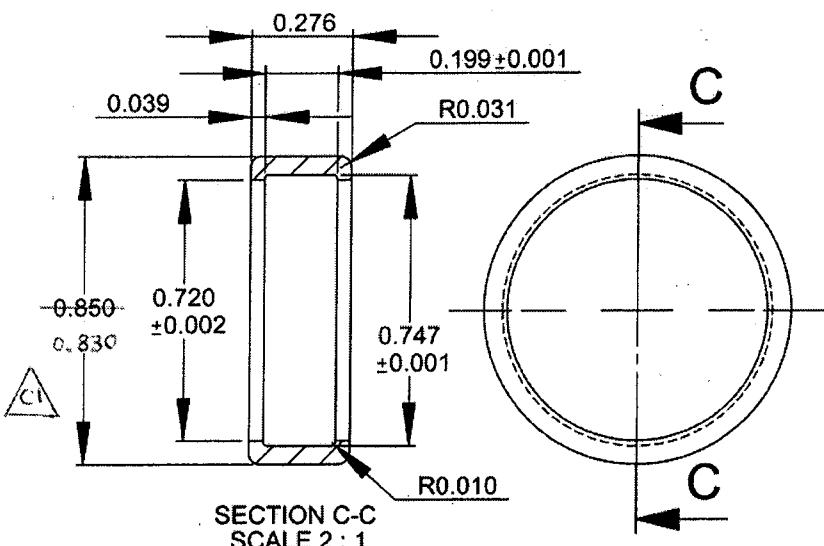
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36921

D3183-9 CAP NO. *36921*

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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